

Work Order ID 132062

Friday, April 24, 2015 9:14:30 AM

132062

Page 1

Item ID: D4049-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Lug Assembly. LH

Start Date: 4/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MC*Date: *150424* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4049

B

100 Weld per dwg A/R S.S. rod Batch: *M123803* 0.00***100***

Large Fab

Memo

0.00

Large Fab

1- Weld lug on bracket as per dwg D4049 using DT9584 jig
2- Tack weld a piece of s.s. rod on back of D4049-3 where lug is located, to hang the part when powdercoating.

2 15-5-4
P.T.O.

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

*⑥ 15-05-05*DAS
9
9-89

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Memo

0.00

Quality Control

*④ 15-05-05*DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only



Work Order: <u>132062</u> Part No. <u>D4049-041</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>15/05/05</u>		Step #: <u># 100</u>		QTY Effective: <u>x1</u>		MRB (QSI042) Approval <u>S 15/05/05</u>																																																																	
Description Work Order Deviation QTY x1 TAKEN FOR trial Fitting and Eng. Review, and other use for ship to customer *Other one use for Future jig with Feed back from customer. Engineering will be holding part				Disposition RED tag + MARK FOR engin use only. Change QTY x1 For Work order.				Completed By <u>SAD 15/05/05</u> Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>150505</u> QC / QA Coordinator Approval <u>S 15/05/05</u>																																																															
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Work Order ID 132062

Friday, April 24, 2015 9:14:30 AM

132062

Page 2

Item ID: D4049-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mounting Lug Assembly, LH

Start Date: 4/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

M 131545

Powdercoat

Memo

0.00

Powder Coating

1- POWDER COAT

Start Time: 10:00

Oven Temperature: 400°

Finish Time: 10:50

2- When powdercoated, ONLY grind off welding rod flush

DAS

3- touch up with paint B#132024

41

9-89

15-5-8

1 15-5-6 DAS 34 9-89

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

① 15-05-08

DAS

9

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval			
Description Work Order Deviation				Disposition				Completed By			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

Work Order ID 132062

Friday, April 24, 2015 9:14:30 AM

132062

Page 3

Item ID: D4049-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Lug Assembly, LH

Start Date: 4/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

145

QC5- Inspect part completeness to step on W/O

0.00

145

QC

Memo

0.00

Quality Control

① 15-05-08

DAS
9
9-89

150

Identify as per dwg & Stock Location: ST-084

0.00

150

Packaging

Memo

0.00

Packaging

1 ~~15~~
15/08/05

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5

MAY 09 2015

① 15-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, April 24, 2015 9:14:35 AM

Page 1

Work Order ID: 132062

132062

Parent Item: D4049-041

D4049-041

Parent Item Name: Mounting Lug Assembly, LH

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.02.11 verified by:JLM IPP Rev:B as
per dwg revA DD 10.02.18 verified by:EC IPP Rev:C as per revB
DD 10.04.23 verified by:EC IPP Rev:D 10.05.04 add note in seq
100 DD verified :EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4049-1

Manufactured No

100

Each

2.0000

1

1

D4049-1

Lug

**

Q 15-4-28

132107X1

Location

WA002

130130

Loc Qty

2

2

Loc Code

D4049-3

Manufactured No

100

Each

2.0000

1

1

D4049-3

Mounting Plate, LH

**

Q 15-4-28

132108X1

Location

WA002

129440

Loc Qty

2

2

Loc Code

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					